

Date: Tuesday, 7/4/2006 3:37:01 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, INBOARD, LS, 206
Job Number	: 27770		
Estimate Number	: 10820		
P.O. Number	: N/A	Part Number	: D26661
This Issue	: 7/4/2006 S.O. No. : N/A	Drawing Number	: D2666 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 27770	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 7/25/2006 Qty: 8 Um: Each
Checked & Approved By	: <u>06.07.04</u>		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: 025344

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

2-Fixturing Inspection last completed on 06/08/06 by JL

3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

9- Deburr

JL 06/08/06

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

JL 06/08/06

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 06/08/06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/4/2006 3:37:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 27770

Part Number: D26661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.08.08

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SC 06/08/09 (8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M 06-08-10 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AL 06/08/11 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST471

AL 06/08/11 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/08/11 (8)

Job Completion



C Log 10/02/14

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27770
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.121	.122	.120		
B	0.100	0.140		.123	.123	.124	.125		
C	2.470	2.510		2.485	2.485	2.485	2.485		
D	0.100	0.180		.135	.135	.135	.135		
E	0.210	0.230		.222	.223	.225	.224		
F	1.313	1.343		1.328	1.327	1.330	1.330		
G	0.240	0.260		.252	.251	.252	.250		
H	0.615	0.685		.655	.655	.655	.655		
I	1.125	1.145		1.132	1.134	1.133	1.134		
J	0.990	1.010		1.001	1.000	1.000	1.000		
K	0.235	0.240		.238	.238	.239	.238		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120	EC	.112	.109	.110	.111		
N	1.565	1.585	DT8682	Contact measure					
O	5.990	6.010		5.998	5.998	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.500	.501	.501		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.500	2.500	2.500	2.499		
U	1.357	1.367		1.362	1.362	1.361	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.550	.550	.551	.550		
X	1.674	1.684		1.679	1.678	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JI
Date: 06/08/06

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	277710
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.125	.124	.124		
B	0.100	0.140		.125	.126	.126	.124		
C	2.470	2.510		2.485	2.485	2.485	2.485		
D	0.100	0.180		.135	.135	.135	.135		
E	0.210	0.230		.226	.225	.225	.225		
F	1.313	1.343		1.330	1.330	1.331	1.331		
G	0.240	0.260		.254	.257	.256	.256		
H	0.615	0.685		.655	.655	.655	.655		
I	1.125	1.145		1.133	1.134	1.133	1.132		
J	0.990	1.010		1.000	1.001	1.000	1.000		
K	0.235	0.240		.238	.238	.238	.238		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.112	.111	.112	.110		
N	1.565	1.585							
O	5.990	6.010		5.998	5.998	5.998	5.998		
P	1.245	1.255		1.230	1.230	1.230	1.230		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.498	.497	.498	.497		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.550	.550	.551	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

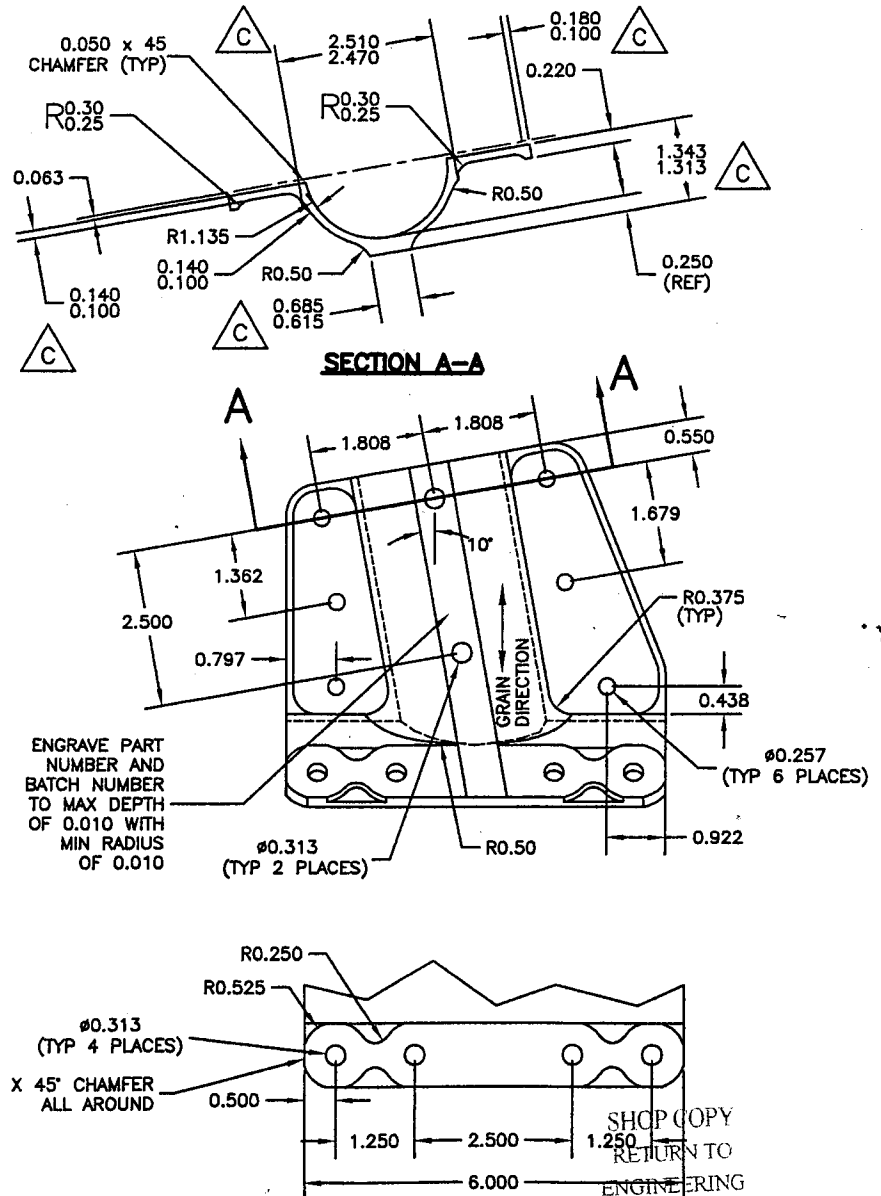
Measured by:	SA
Date:	06.08.08

Audited by:	SL
Date:	06/08/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART**RELEASED**
66-6-28

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED B	APPROVED #	DRAWING NO. D2666	REV. C SHEET 1 OF 1
DATE 06.05.26	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	

**D2666-1 SADDLE FWD INSIDE HIGH****NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 27770

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